

5/22

(3)

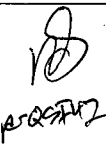
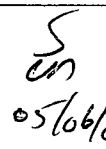
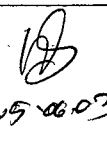
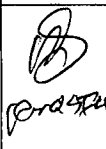
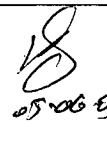
<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	<b>23235</b>
<b>Description:</b> Short Pin Bracket	<b>Part Number:</b>	<b>D3330-13</b>
<b>Dwg:</b> D3330 Rev. <i>AB</i> <i>05.01.16</i> PAGE 9 RF 05.01.17	<b>Qty:</b>	<b>15</b>
		Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler	<i>JA</i>	05.05.11	15
2	MV	Cut blanks: 2.500" x 1.000" x 5.00" long (+/-0.030) Material: AISI 1010-1025 or ASTM A36/A366/A569/A570 Cold Rolled Steel (M1010-B2.500x01.000) Identify for D3330-13 Batch: <i>M17668</i>	<i>JL</i>	05/06/01	15
3	MV	Machine as per Folio FA480 and Dwg D3330 Identify as D3330-13	<i>CP</i>	05/06/03	15
4	QC2	Inspect parts as they come off the CNC machine	<i>CP</i>	05/06/03	15
5	QC8	Second check	<i>PL</i>	05/06/03	15
6	MV	Deburr	<i>JL</i>	05/06/04	15
7	QC5	Inspect work to Step 6	<i>PL</i>	05/06/03	15
8	ST	Identify and Stock	<i>CD</i>	05/06/06	15
9	AC	Cost / part: <i>16.50</i>	<i>AP</i>	05/06/07	15
10	DC	Close W/O <i>16.49</i> Inspect Level 21	<i>JA</i>	05.06.08	15

Rev	Date	Change	Revised By	Approved
A	05.01.13	New issue	KJ/JLM	<i>[Signature]</i>

RELEASED  
05/01/17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE.	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR: 23235		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
05/06/03	#3	one part scrap moved in use <hr/> two parts scrap <del>two</del> parts cut too small		scrap & replace	 05/06/03	 05.06.03	 05.06.03	 05.06.03

Part No: D3330-13

PAR #:

Fault Category: Prod/machined

NCR: <sup>PARB</sup>

Yes No

DQA:

Date: 05/06/08

NOTE: Date &amp; initial all entries

QA: N/C Closed:

Date: 05.06.08

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	23235
<b>Description:</b> Short Pin Bracket		<b>Part Number:</b>	D3330-13
<b>Inspection Dwg:</b> D3330 <b>Rev:</b> B		<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article      ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.00	+/-0.030	2.986	✓			
2.625	+/-0.010	2.623	✓			
0.260	+/-0.010	0.258	✓			
Ø0.594	+0.005/-0.000	0.597	✓			
0.625	+/-0.010	0.625	✓			
0.500	+/-0.010	0.490	✓			
2.25	+/-0.030	2.251	✓			
Ø0.531	+0.005/-0.000	0.534	✓			
0.950	+/-0.010	0.954	✓			
Ø0.348	+0.005/-0.000	0.348	✓			
Ø0.467	+/-0.010	0.457	✓			
1.250	+/-0.010	1.249	✓			
1.00	+/-0.030	0.996	✓			
0.10 x 45°	+/-0.030	0.097 x 45°	✓			
Ø0.516	+0.005/-0.000	0.517	✓			

<b>Measured by:</b>	ED	<b>Audited by:</b>	gnd	<b>Prototype Approval:</b>	N/A
<b>Date:</b>	05/06/02	<b>Date:</b>	05/06/03	<b>Date:</b>	N/A

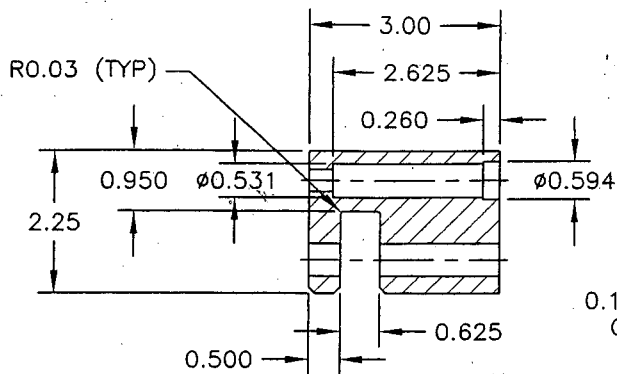
Rev	Date	Change	Revised by	Approved
A	05.05.10	New Issue	KJ/JLM	

RELEASED

05/05/10

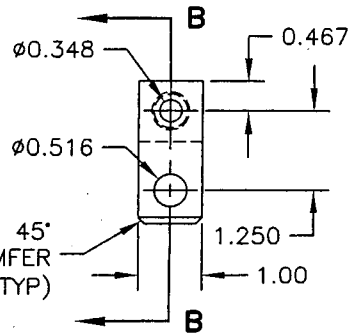


DESIGN <i>AS</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3330	REV. B SHEET 9 OF 9
DATE 05.02.26		TITLE FRAME WELDMENT	SCALE 1:3

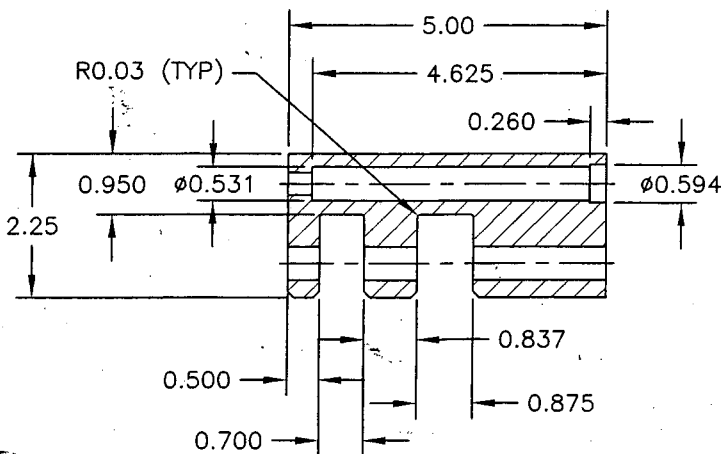
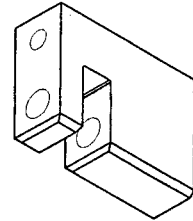


**SECTION B-B**

**D3330-13 SHORT PIN BRACKET**

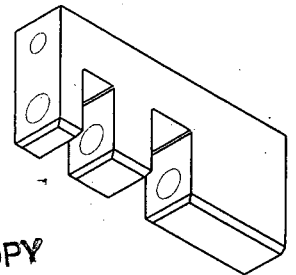
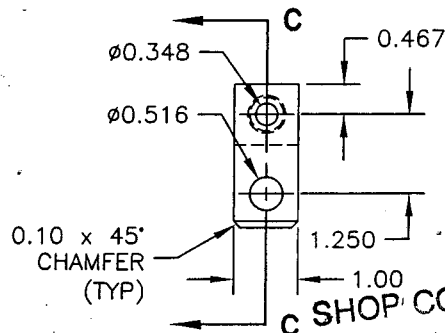


RELEASED  
*[Signature]*  
05/04/15.



**SECTION C-C**

**D3330-11 LONG PIN BRACKET**



UNCONT  
SUBJECT  
WITH  
WORK ORDER  
NO. 23235  
COPY  
RETURN TO  
ENGINEERING

**NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570, 1.000 THICK STEEL (REF. DART SPEC. M1010-B1.000x02.250)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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# Job Costing Report

Dart Aerospace Ltd.  
Hawkesbury

May 09, 2005  
02:16 pm

Work Order No : 0023235  
Project Name : D3330-13  
Project For : WK522  
Work Order Type : Main  
Main WO Number :  
House Part Number : D3330-13  
Description : Short Pin Bracket  
Manufactured : Yes  
Amount Req'd : 15  
Amount Done : 0  
Start Date : 05-09-05  
Est Finish Date : 05-31-05  
Act Finish Date :  
Drawings Req'd : No  
Ok for Approval :  
Approval Rec'd :

Department Code:  
Burden Flags : NNNNNNNN  
WO Status : Open  
Invoice State : Not Invoiced  
Invoice Date :  
Invoice Number :  
Invoice Amount : 0.00  
Order Entry No :  
OE Value : 0.00  
Est Mark Up : 0.000%  
Actual Mark Up : 0.000%  
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00